

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017498**Date Inspected:** 27-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Yu Dong Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044541/054460 perform SMAW welding on; Tower Lift 5 Bracket components and the weld joint is identified as ND1-BRSA5-1- 10A, 14B. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U4B. (Photo attached)

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040655 / 040723 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A5-021-135, 134. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2313-B-U2.

Bay no. 10

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 057266/ 057180 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A5-029-076, 077. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's

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calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053116/054069 perform FCAW welding on; OBG bike path components and the weld joint is identified as BK 004A5-082, 083. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

5. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050289 perform SMAW Buttering welding on; Tower Internal stiffener splice plates and the Splice plate weld is identified as SA5 -6 . ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with 485-SMAW-2G (2F)- Repair. (Photo attached)

Ultrasonic Testing:

This QA inspector, Baskar Govindarajan, performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted at Tower components by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report for this date. The member is identified as East shaft, Lift 3, and West shaft, Lift 3 of 89 mtr. and South shaft, Lift 3, and North shaft, Lift 3 of 99 mtr. elevation at Heavy Dock, Tower trial assembly area (Notification nos. 006781 and 06783). The weld designation reviewed is as follows:

ESD1- FASA3-2C/E – Jt. nos – 13,14,18,19,26 –East shaft, Lift 3-89mtr.

WSD1-FASA3-2 C/E-Jt. nos.- 13,14,18,19,20- West shaft, Lift3 -89 mtr.

NSD1- FASA3-1B/E – Jt. nos – 21,23,27,28,31 –North shaft, Lift 3-99mtr.

SSD1- FASA3-1B/E – Jt. nos – 21,23,27,28,31 –South shaft, Lift 3-99mtr.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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